

Work Order ID 75817

75817

Page 1

October-31-11 12:43:07 PM

Item ID: D2330-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Frame
 Start Date: 31/10/2011 Start Qty: 4.00 ***4*** *let* Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 4.00 ***4*** *let* Customer:
 Reference:



Approvals: Process Plan: M.L.J Date: 11/10/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2330	H								

100 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Cut tube as per dwg D2330
 2- remove identification marks and deburr *let* *Ø*

110 0.00
110
 QC Memo 0.00
 Quality Control *QC* *8/2/09* *let* *Ø* *PTO*

120 0.00
120
 Packaging Memo 0.00
 Packaging Identify as per dwg & Stock Location: WA *let* *Ø*

W/O: 75817		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.02.08	110	change to QC 6		12.02.08			 12/02/08

Part No: D2330-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75817

October-31-11 12:43:07 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 31/10/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 14/11/2011 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept
Qty

Reject
Qty

Reject Number

Insp. Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

M.L.J 12/02/09

M.L. 5 12/02/09

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Picklist Print

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Page 1

Work Order ID: 75817

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Parent Item: D2330-1

D2330-1

Parent Item Name: Frame

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC
10.11.30 AS PER DWG REV.H DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased		No		100	f	506.7499	7.37	31.03158			
M304TS0 750W 065									**			Pl 12.02.08	
304 SQ Tube .75x.75x.065W													

Location

Loc Qty

Loc Code

MAT018

485.0857585

117636

67.9987

118773

417.087059

WA

6.0667

118181

6.0667

WA007

15.5974906

~~116267~~

14.628472

116763

0.9690186

M120267 → 44.22

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ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75817 M.C.J

11/10/31

RELEASED
2010-11-25

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	09.09.14
C	ADDED LATCH AND LABEL PLATE	BK	06.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2330	SHEET 1 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	BASKET ASSEMBLY (206B)	NTS
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DATE	10.09.28		

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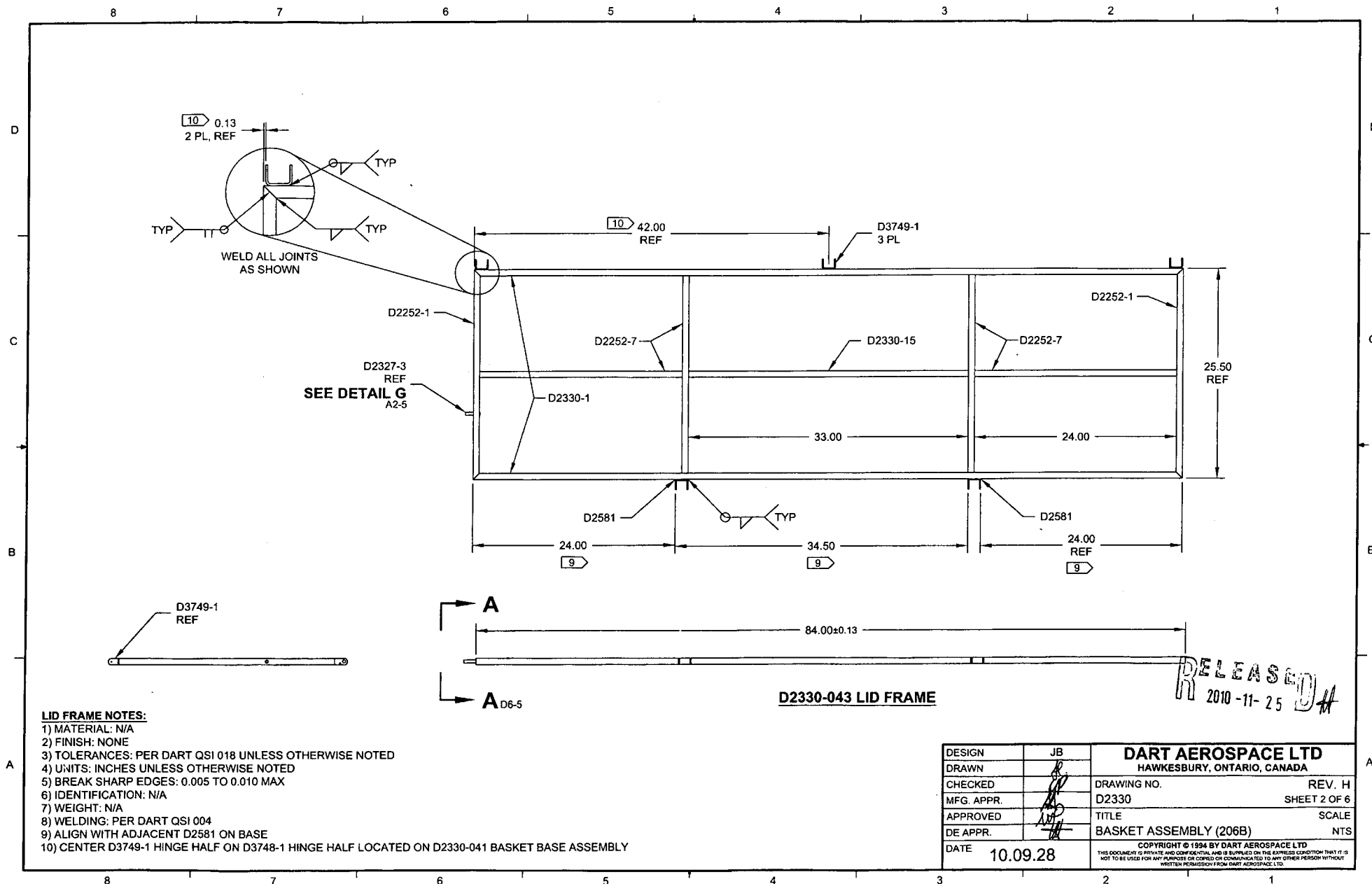
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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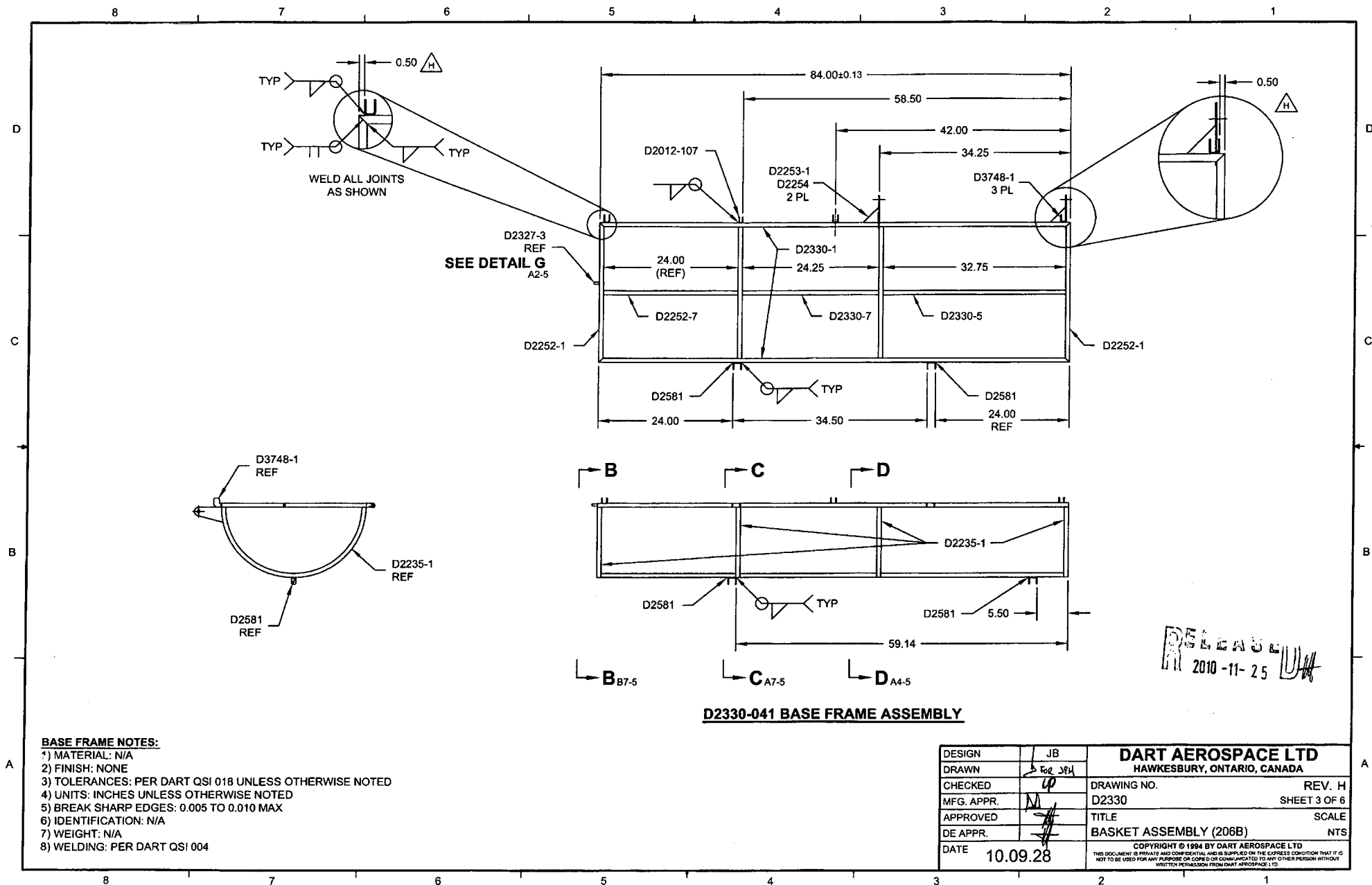
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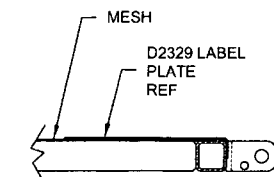
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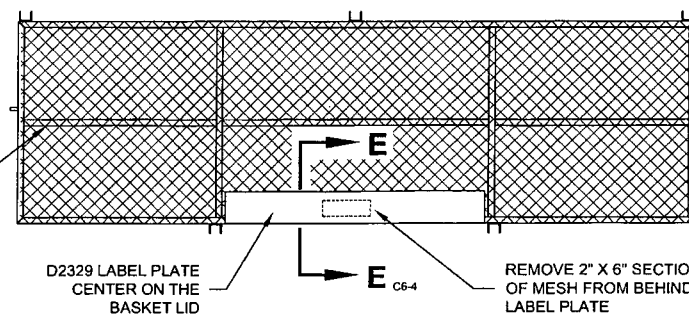
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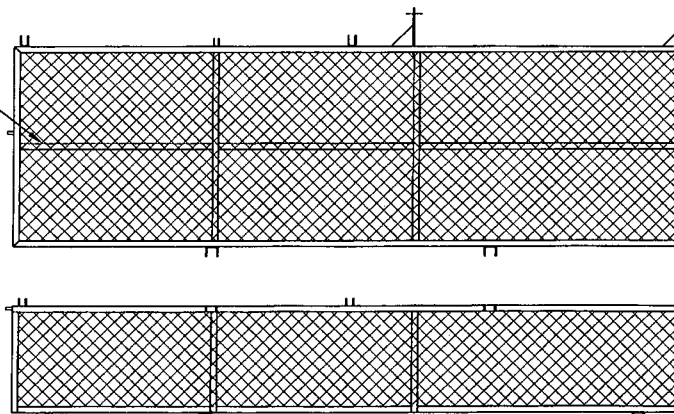


SECTION E-E C3-4
VIEW ROTATED 90° CCW

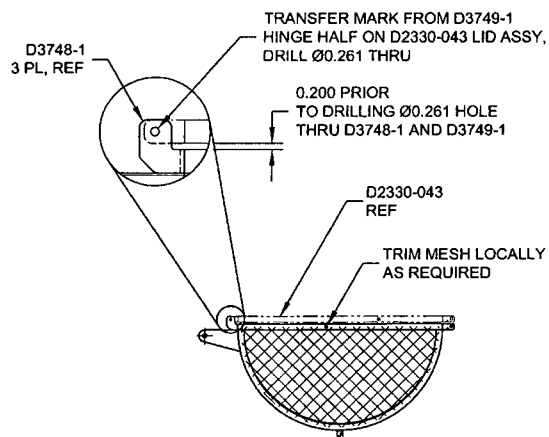
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY








D2330-041 BASE ASSEMBLY



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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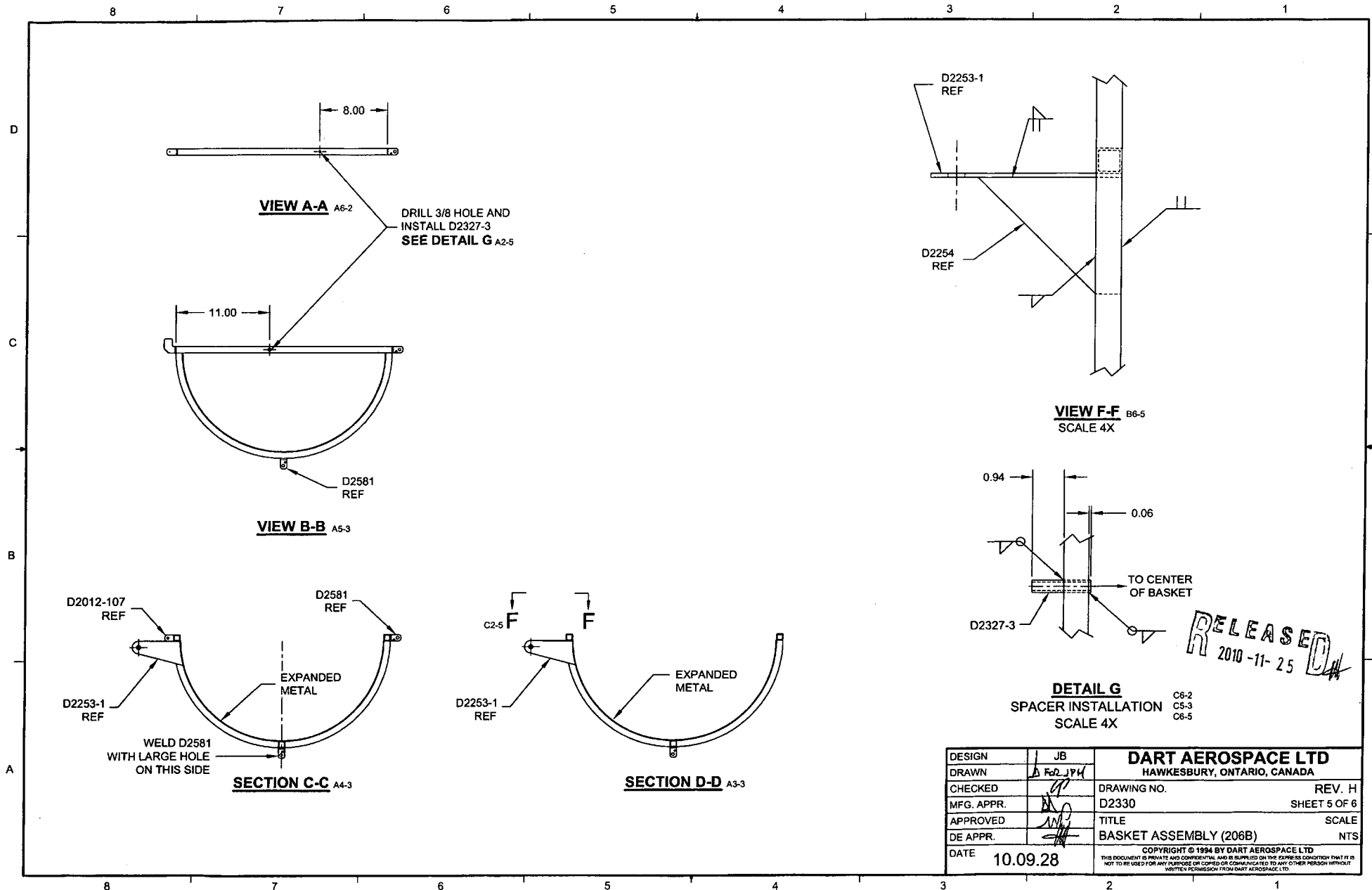
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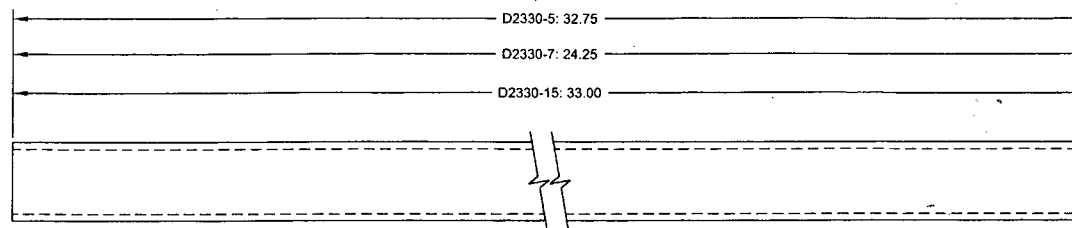
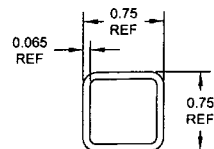
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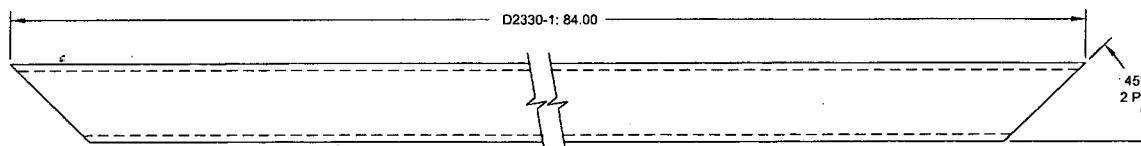
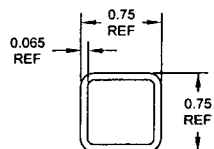
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D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

RELEASED
 2010-11-25

- NOTES:**
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
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